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(54) SHOT PEENING METHOD

(57) Abstract:

PURPOSE: To execute a shot peening process of constant arc height to a material to be processed by controlling projection time so as to make a product of an average grain size of a shot peening grain raised to the third power and projection time a constant value, according to the variation in the average grain size of the operating shot peening grain.

CONSTITUTION: In a device in use, relation between a motor current I and an average grain size d of a shot peening grain is experimentally examined, so as to preliminarily determine constants (a) , (b) , whereby projection time t can be calculated based on an aimed arc height value h and on the motor current I by an operation means B without measuring average grading of a shot each time. By executing a shot peening process of the projection time t , irrespective of a variation in a shot peening grain size, process intensity of the aimed arc height value h can be obtained constantly.

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